

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. F OR EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 3 OR EARLIER
REF CANADIAN STC: SH92-18
FAA STC: SH989NE
FAA STC: SH990NE
REF. EASA STC: EASA.IM.R.S.01561

1.0 Purpose

The purpose of this service instruction is to add the D350-567-141/-143/-145/-147/-149 Close-out Kits, which are intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141/-143/-145/-147/-149 Floor Window Close-out Kits provide a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1. The -143 Kit is identical to the -141 Kit with the exception of the D4971-041 T/R Bellcrank Cover Assy which replaces the D4435-045 T/R Bellcrank Cover Assy on aircraft fitted with energy attenuating seats. The -145 Kit is similar to the -143 Kit but is only kit compatible with the AS350B3e aircraft. The -147 kit is the same as the -145 kit except it is compatible with the AS350B3e equipped with the Garmin Transponder. The -149 Kit is similar to the -145 Kit, but is compatible with later model AS350B3e equipped with the Garmin Transponder.

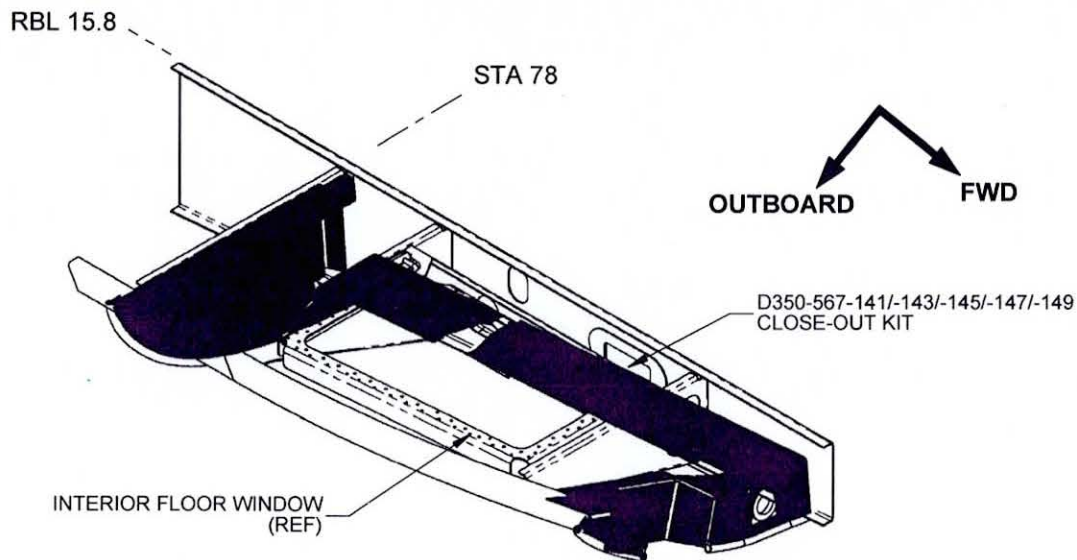


Figure 1. Floor Window Close-out Kit Installation



J	REPLACED D4436-045 WITH D4436-051 ON D4436-047 (-147/-149 KITS); UPDATED FIGURES 3 THRU 7, 10, 15 & 16. UPDATED NOTES 4.03, 4.1, 4.2, 4.6, 4.7, 4.9 & ADDED 4.12d. REASON ECR 470	RF	23.01.03
H	ADDED D350-567-149	RF	22.03.04
G	ADDED D350-567-147	VS	18.09.22
F	ADDED D4434-047 TO -141 KIT SEE PAR14-372.	AJS	15.01.12
E	ADD -143/-145 KITS	RF	14.03.20
D	CLARIFY FIGURES 3-12	VS	13.09.11
C	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P	RF	12.03.13
B	MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525-832R7, NAS1149FN882P & MS21042L08	RF	12.02.22
A	NEW ISSUE	RF	12.01.09
REV.	DESCRIPTION	BY	DATE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 23.01.03
CERT. NO.: SH92-18
ISSUE NO.: 6

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MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 22
APPROVED	SAD	TITLE	SCALE
DE APPR.	DS	FLOOR WINDOW CLOSE-OUT KIT	NTS
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2.0 Parts List



Qty -141	Qty -143	Qty -145	Qty -147	Qty -149	Part Number	Description
X					D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X				D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X			D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS350B3e)
			X		D350-567-147	FLOOR WINDOW CLOSE-OUT KIT (AS350B3e WITH GARMIN TRANSPONDER)
				X	D350-567-149	FLOOR WINDOW CLOSE-OUT KIT (LATER MODEL AS350B3e WITH GARMIN TRANSPONDER)
1	1	1	1	1	D3802-1-024	SEAL (24")
1	1				D4434-041	FWD BRACKET ASSEMBLY
1	1				D4434-047	COVER ASSEMBLY
1					D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	2	2	D4435-9	BRACKET
1	1	1			D4436-041	AFT BRACKET ASSEMBLY
			1	1	D4436-047	AFT BRACKET ASSEMBLY
1	1	1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	1	1	D4730-020-030	VELCRO STRIP
	1	1	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1			D5076-041	FWD BRACKET ASSEMBLY
			1		D5076-047	FWD BRACKET ASSEMBLY
				1	D5920-041	FWD BRACKET ASSEMBLY
7	5	5	5	5	AN3-3A	BOLT
2	2	2	2	2	AN525-10R6	SCREW
2	2	2	2	2	AN525-832R7	SCREW
		1	1	1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	2	2	MS21059L3	NUTPLATE
7	7	7	7	7	MS35206-229	SCREW
12	10	10	10	12	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

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3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145/-147/-149 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145/-147/-149	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145/-147/-149 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145/-147/-149 Close-out Kits as required to improve fit. Deburr and touch up new holes and trimmed edges with MIL-P-85582 or MIL-P-23377 primer.
- Once the D350-567-141/-143/-145/-147/-149 Floor Window Close-out Kit has been installed, there must be no large openings thru the Close-out kit structure into the belly of the aircraft. If a large opening exists (because a piece of equipment is missing, for example) the applicable floor window must be re-installed prior to the next flight.

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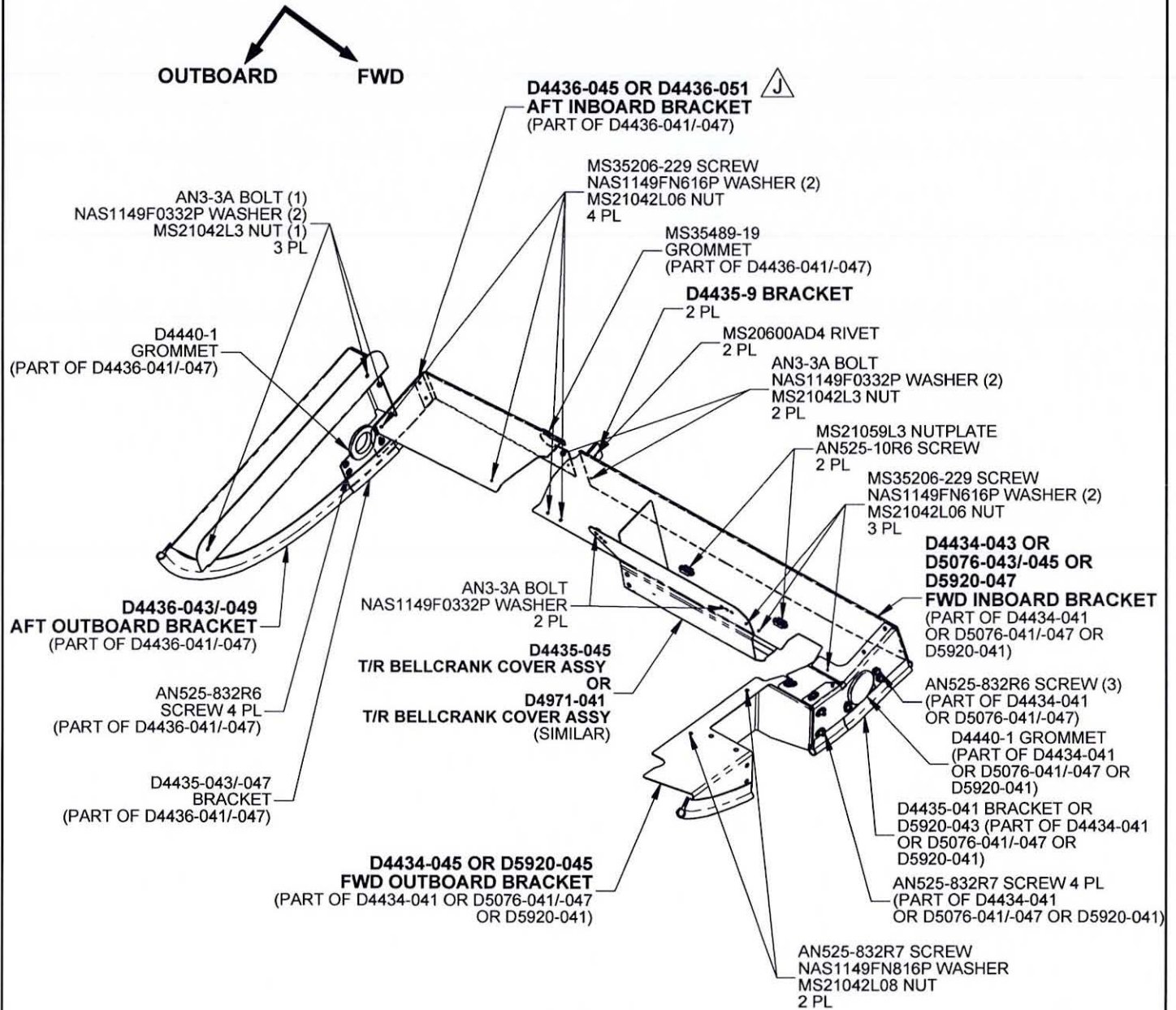


Figure 2. Floor Window Close-out Kit Installation △ J
 (-141 shown, -143/-145/-147/-149 similar)

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- 4.1 Temporarily install D4436-043/-049 Aft Outboard Bracket and D4436-045/-051 Aft Inboard Bracket using clecos and/or cleco clamps. Before drilling holes:
- Position the D4436-043/-049 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
 - Confirm that the D4436-043/-049 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.
- 4.2 Temporarily install D4434-043 or D5076-043/-045 or D5920-047 Fwd Inboard Bracket and D4434-045 or D5920-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045/-051 Aft Inboard Bracket and D4434-043 or D5076-043/-045 or D5920-047 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.
- 4.3 For -141 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.4 For -143 installations, if aircraft is equipped with Collective Circuit Breaker Board box, trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4971-041 T/R Bellcrank cover as shown in Figure 13b. Note: Confirm the D4434-047 Bracket fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.5 For -145/-147/-149 installations, if aircraft is equipped with Collective Circuit Breaker Board box, use D5076-043/-045 or D5920-047 Fwd Inboard Bracket as shown in Figure 13c. Install D4971-041 T/R Bellcrank cover as shown in Figure 13c. Note: Confirm the D5076-3 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.6 Drill out rivets holding plastic wire bundle stand offs. Transfer drill $\varnothing 0.144$ holes to D4436-045/-051 Aft Inboard Bracket per Figure 6. Transfer drill 2 x $\varnothing 0.144$ holes to D4434-043 or D5076-043/-045 or D5920-047 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x $\varnothing 0.144$ holes to D4434-043 or D5076-043/-045 or D5920-047 and D4436-045/-051 brackets are flush with outboard edge of main beam flange. Assemble D4436-045/-051 Aft Inboard Bracket and D4434-043 or D5076-043/-045 or D5920-047 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.
- 4.7 Install D4436-043/-049 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9. For -147/-149 installations, ensure the opening in the D4436-049 Aft Outboard Bracket is over the Garmin Transponder per Figure 15.
- 4.8 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x $\varnothing 0.129$ holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.
- 4.9 Drill a pilot hole from D4435-9 Bracket to the D4434-043 or D5076-043/-045 or D5920-047 Fwd Inboard Bracket and D4436-045/-051 Aft Inboard Bracket and open to $\varnothing 0.191$. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.
- 4.10 Transfer drill 2 x $\varnothing 0.144$ holes from crossbeam to D4434-045 or D5920-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x $\varnothing 0.144$ holes at either end of D4434-045 or D5920-045 Bracket as shown in Figure 11. Install AN525-832R7 screws, NAS1149FN816P washers and MS21042L08 nuts.
- 4.11 FOR D350-567-141 KIT**
- Align D4435-045 T/R Bellcrank Cover Assy with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12a.
 - Transfer drill 2 x $\varnothing 0.098$ holes from D4435-045 T/R Bellcrank Cover Assy to D4434-043 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12a and Figure 13a. Install D4435-045 T/R Bellcrank Cover Assy using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12a and Figure 13a.

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4.12 FOR D350-567-143/-145/-147/-149 KIT

- a) Remove the D4972-041 Side Plate Assy from the D4971-041 T/R Bellcrank Cover Assy and retain fasteners.
 - b) Align D4971-1 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12b.
 - c) Bond D4730-020-030 Velcro to back of D4971-1 T/R Bellcrank Cover as shown in Figure 12b using CB 200 adhesive.
 - d) Align the D5920-045 Fwd Outboard Bracket Assy with the D5920-043 Fwd Inboard Bracket Assy in place. Transfer 2 x $\varnothing 0.177$ holes from the D5920-045 Fwd Outboard Bracket Assy to the D5920-043 Fwd Inboard Bracket Assy as shown in Figure 16.
 - e) Transfer drill 2 x $\varnothing 0.098$ holes from D4971-1 Cover Plate to D4434-043 or D5076-043/-045 or D5920-047 Fwd Inboard Bracket. Open holes to $\varnothing 0.191$ and install MS21059L3 nut plate into D4434-043 or D5076-043/-045 or D5920-047 Fwd Inboard Bracket as shown in Figure 13b/13c. Install D4971-1 Cover Plate using AN525-10R6 screws and D4730-020-030 Velcro per Figure 12b and Figure 13b/13c.
 - f) Re-install the D4972-041 Side Plate Assy using the retained fasteners.
- 4.13 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.14 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.15 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.16 Ensure there is a gap between the components of the D350-567-141/-143/-145/-147/-149 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-141/-143/-145/-147/-149 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer of Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.
- 4.17 Update Aircraft Logbook to indicate installation of the D350-567-141/-143/-145/-147/-149 Close-out Kit and adjust Weight and Balance record for the aircraft with the weight and balance data provided in Section 3.0 of this report.

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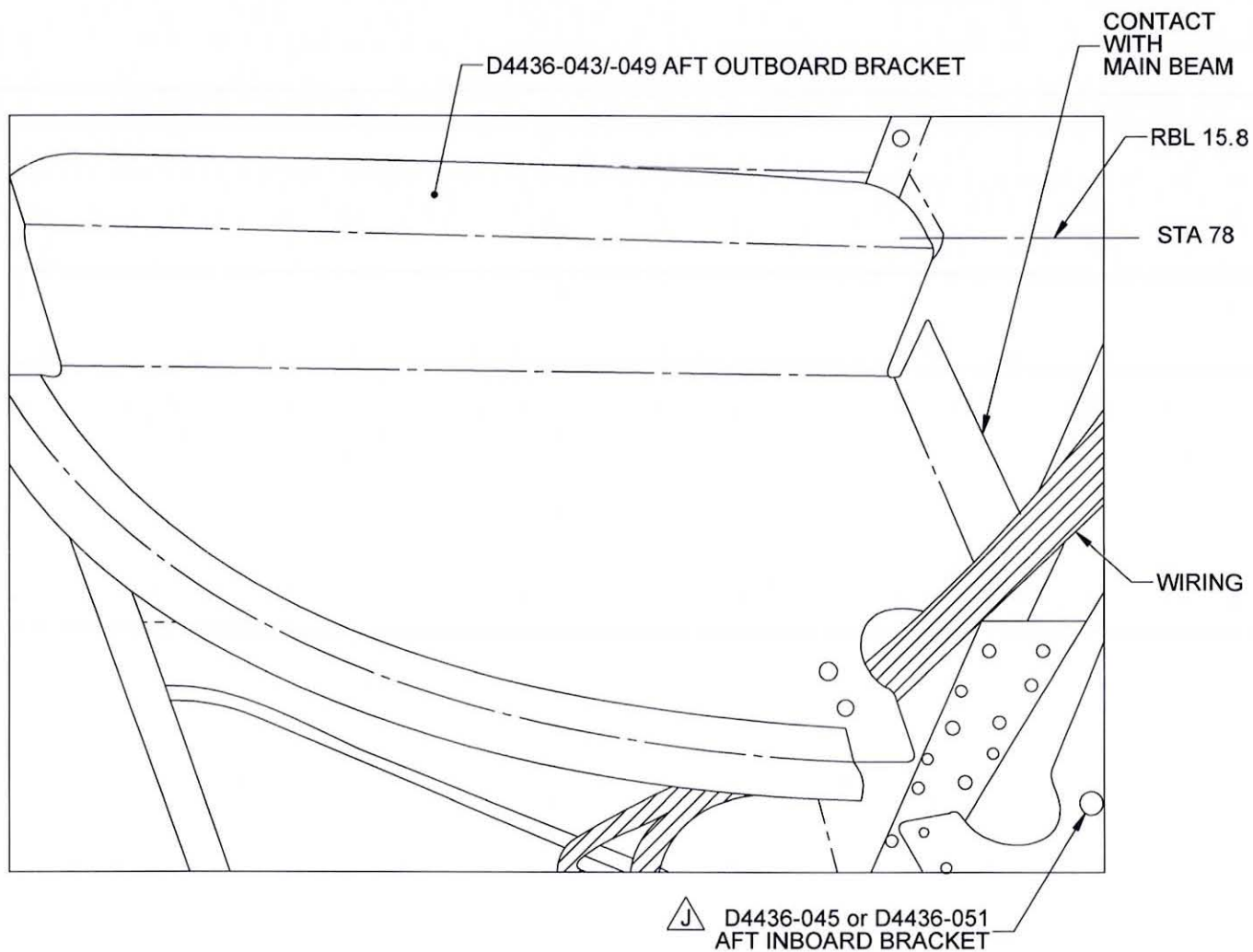


Figure 3. D4436-043/-049 Aft Outboard Bracket Installation ⚠

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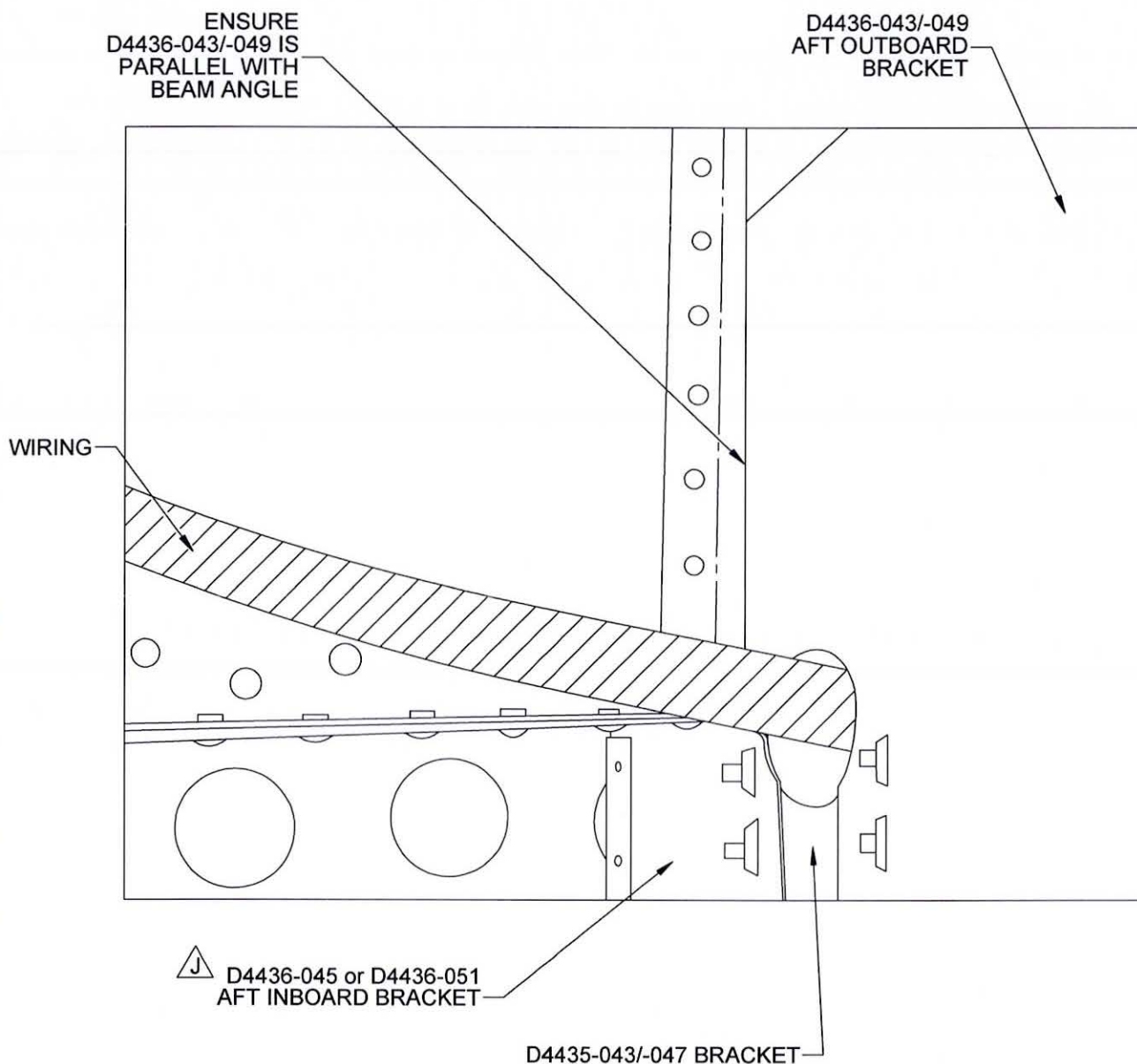


Figure 4. D4436-043/-049 & D4435-043/-047 Brackets Installation ⚠ J

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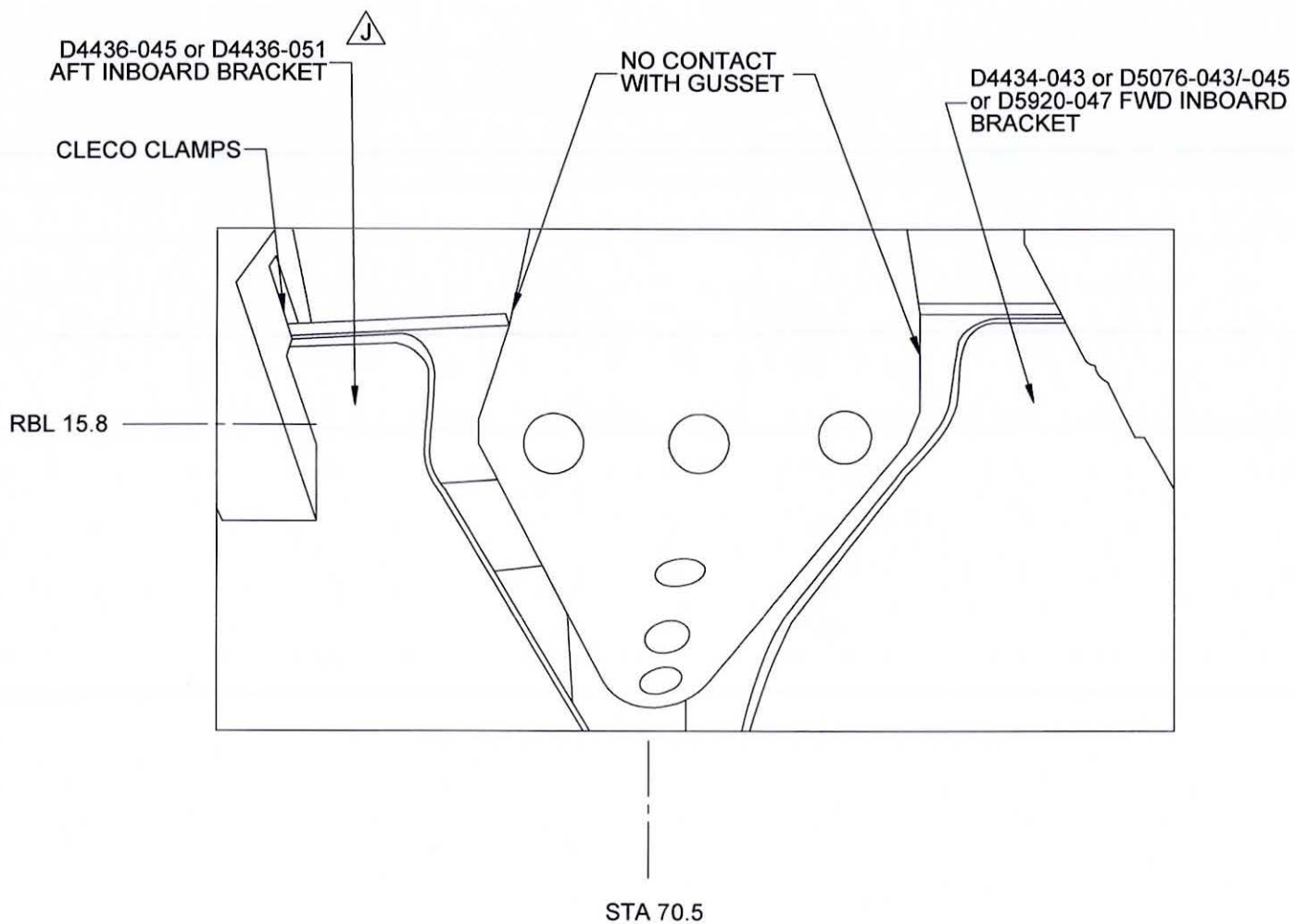


Figure 5. D4436-045/-051 & D4434-043 or D5076-043/-045 or D5920-047 Brackets Installation △ J

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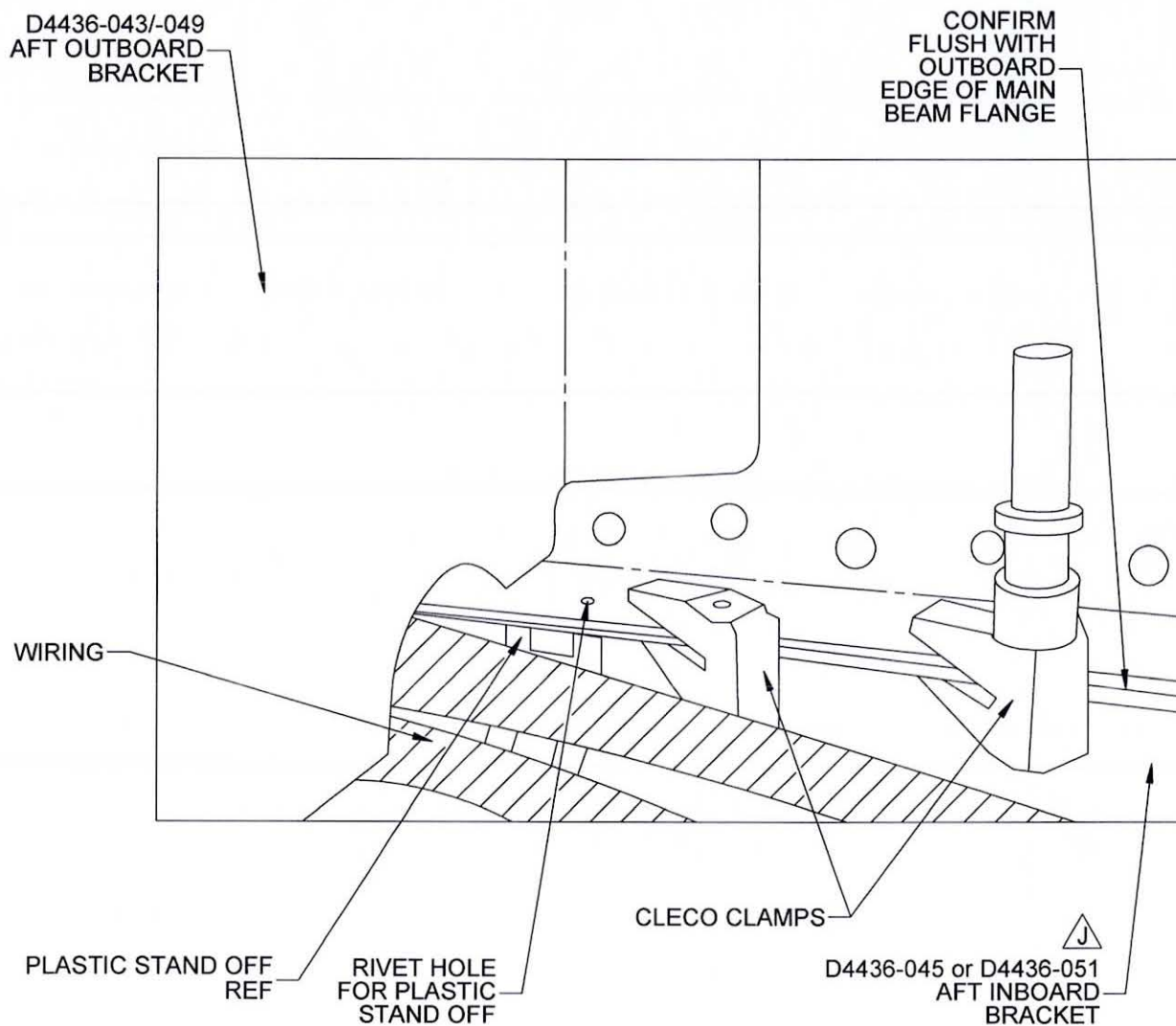


Figure 6. D4436-043/-049 and D4436-045/-051 Brackets Installation J

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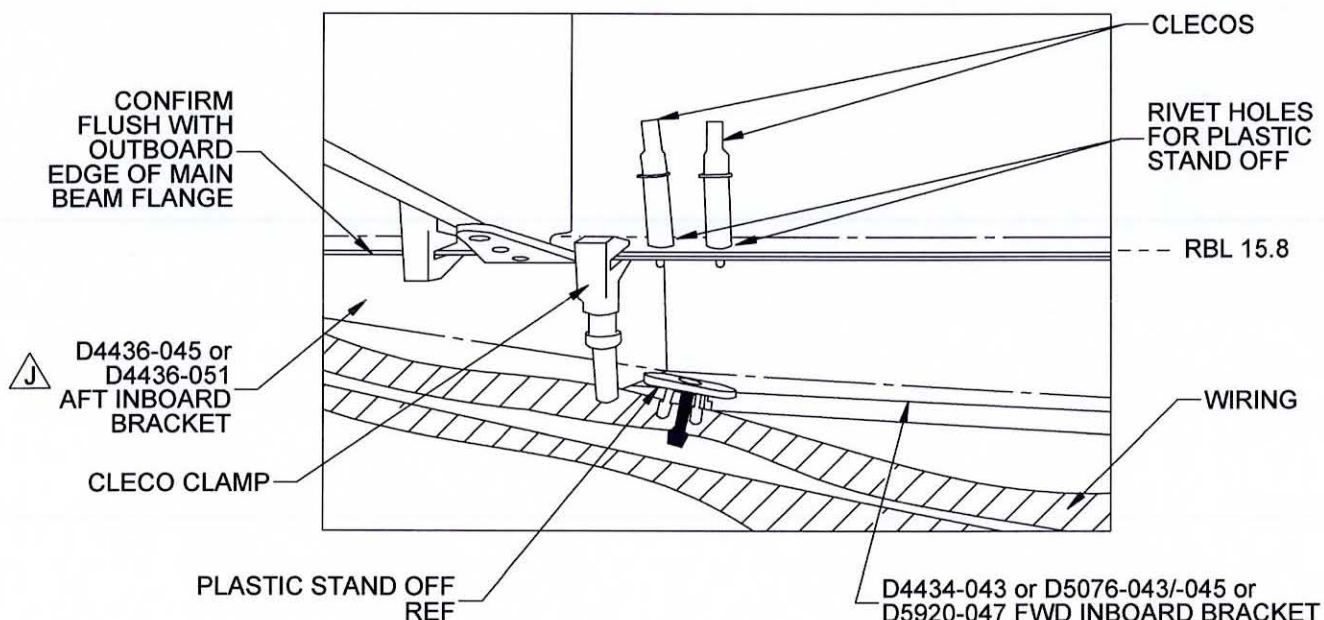


Figure 7. D4434-043 or D5076-043/-045 or D5920-047 & D4436-045/-051 Brackets Installation ⚠

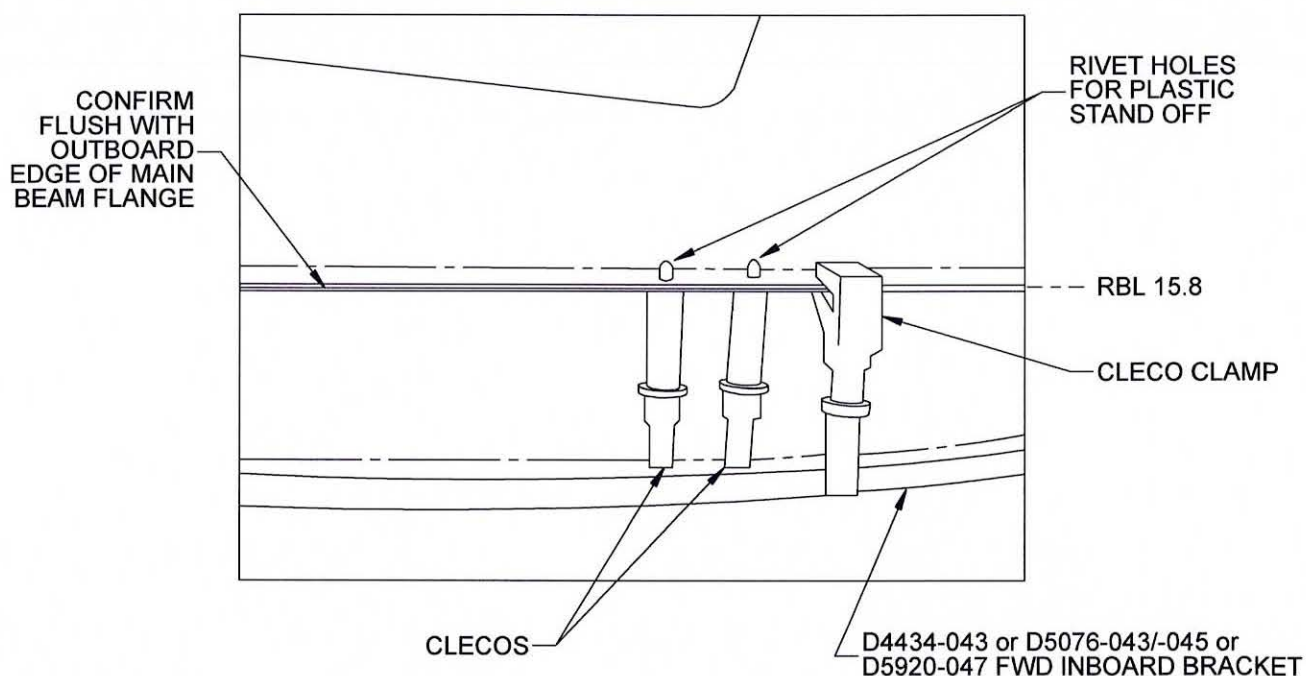


Figure 8. D4434-043 or D5076-043/-045 or D5920-047 Fwd Inboard Bracket Installation

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INSTALL
D4436-043/-049
AFT OUTBOARD BRACKET
USING
AN3-3A BOLT (1)
NAS1149F0332P WASHER (2)
MS21042L3 NUT (1)
3 PL

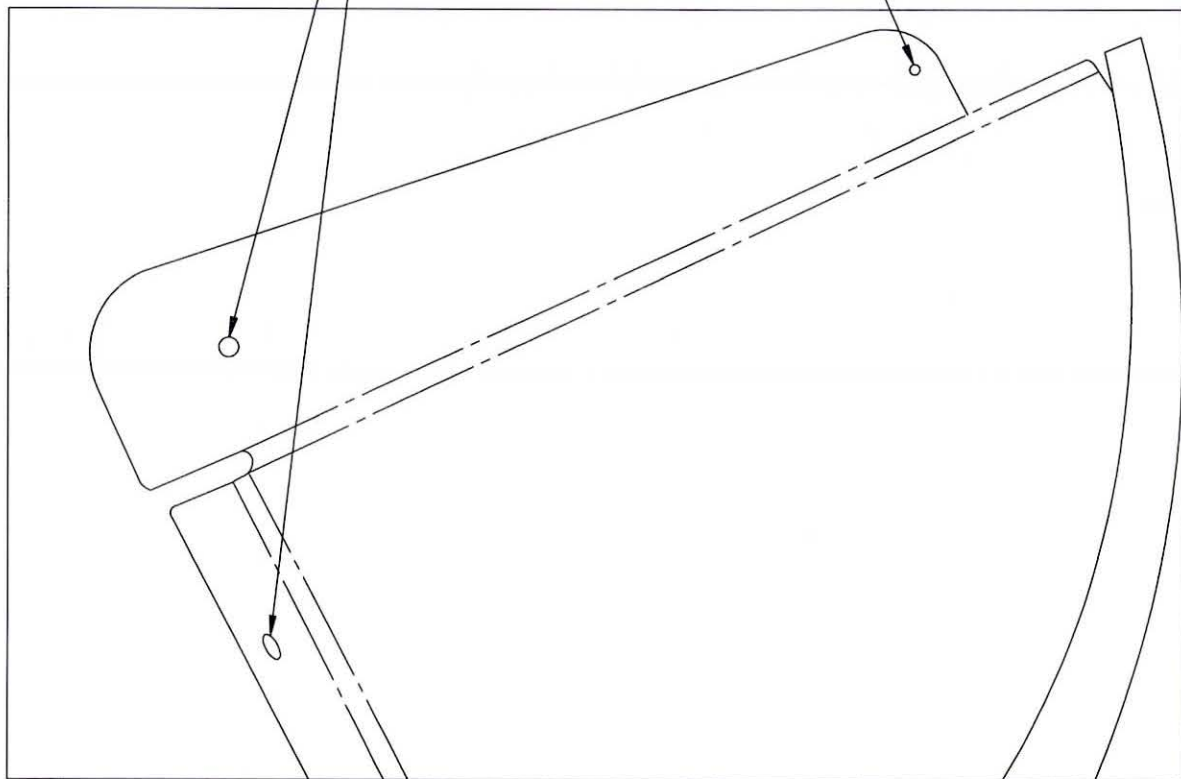
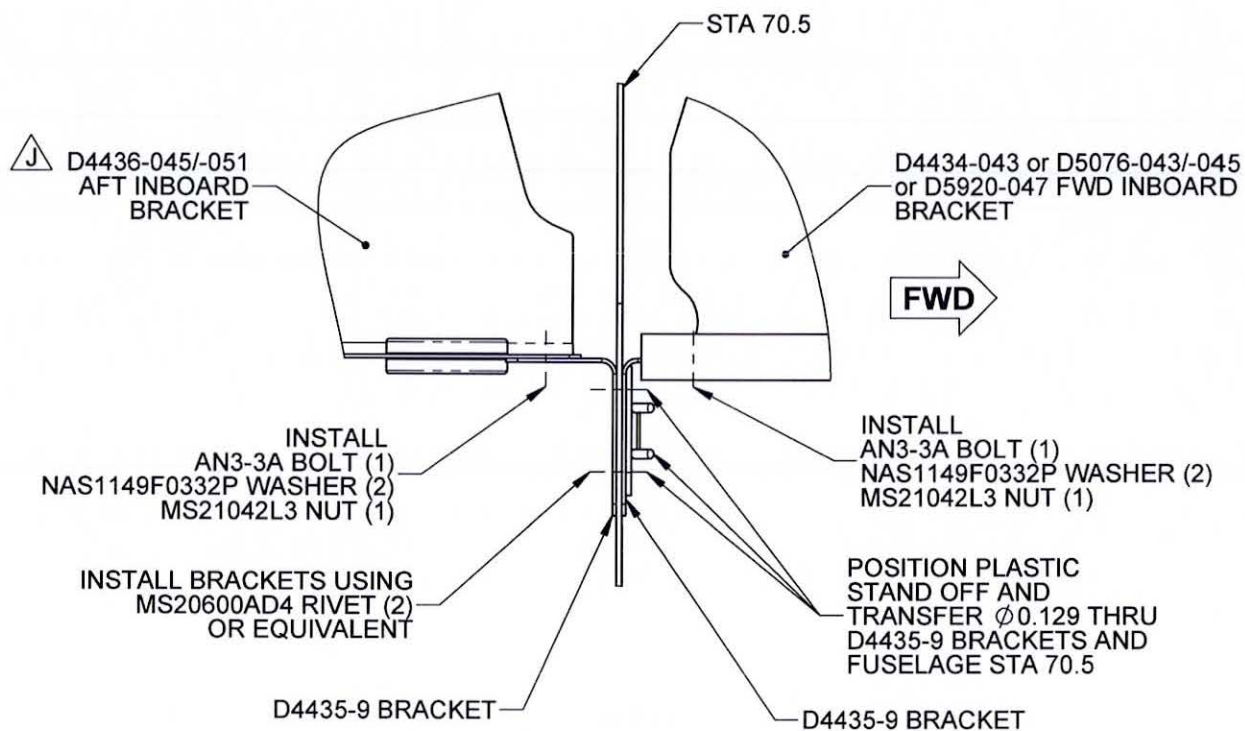


Figure 9. D4436-043/-049 Aft Outboard Bracket Installation

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LOOKING UP AT STA 70.5

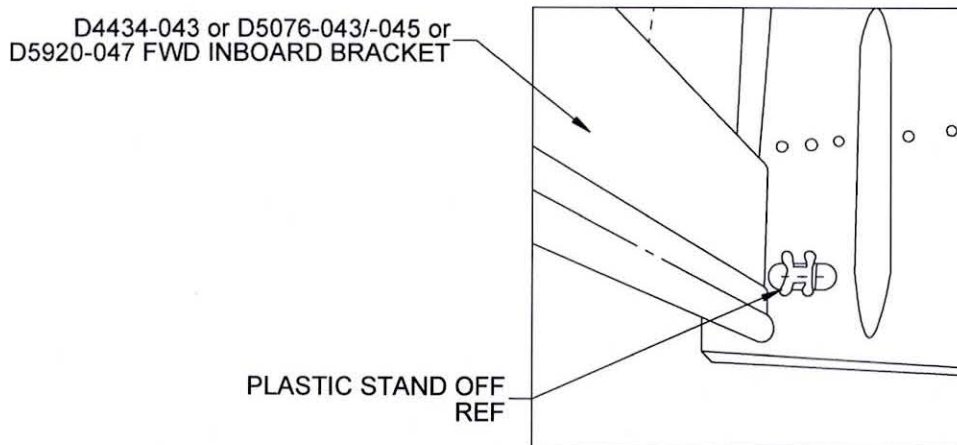


Figure 10. D4434-043 or D5076-043/-045 or D5920-047 and D4435-9 Brackets Installation △ J

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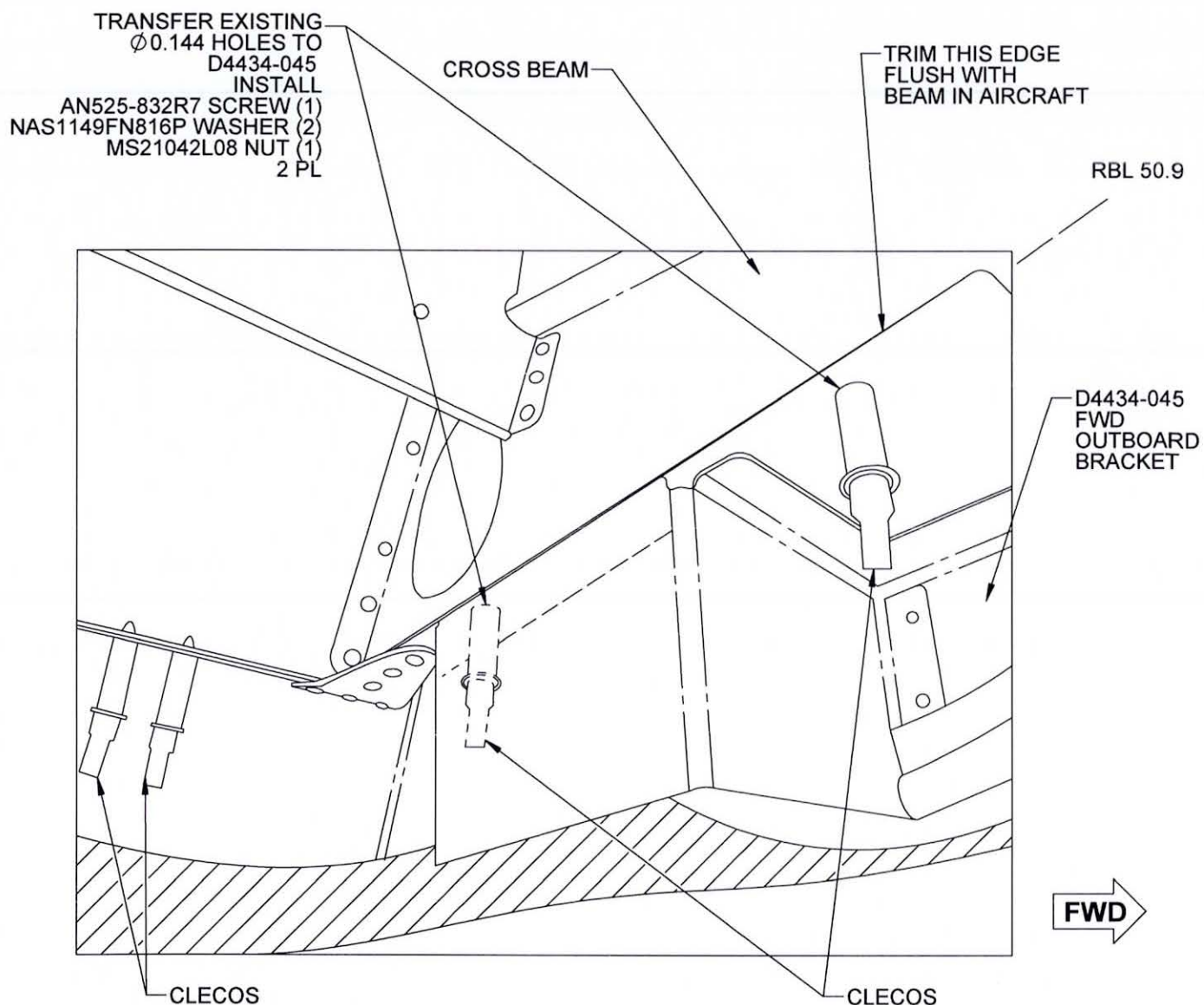


Figure 11. D4434-045 Bracket Installation

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SAD	DRAWING NO.	REV. J
MFG. APPR.	N/A	DSI 9590	SHEET 14 OF 22
APPROVED	SAD	TITLE	SCALE
DE APPR.	DS	FLOOR WINDOW CLOSE-OUT KIT	NTS
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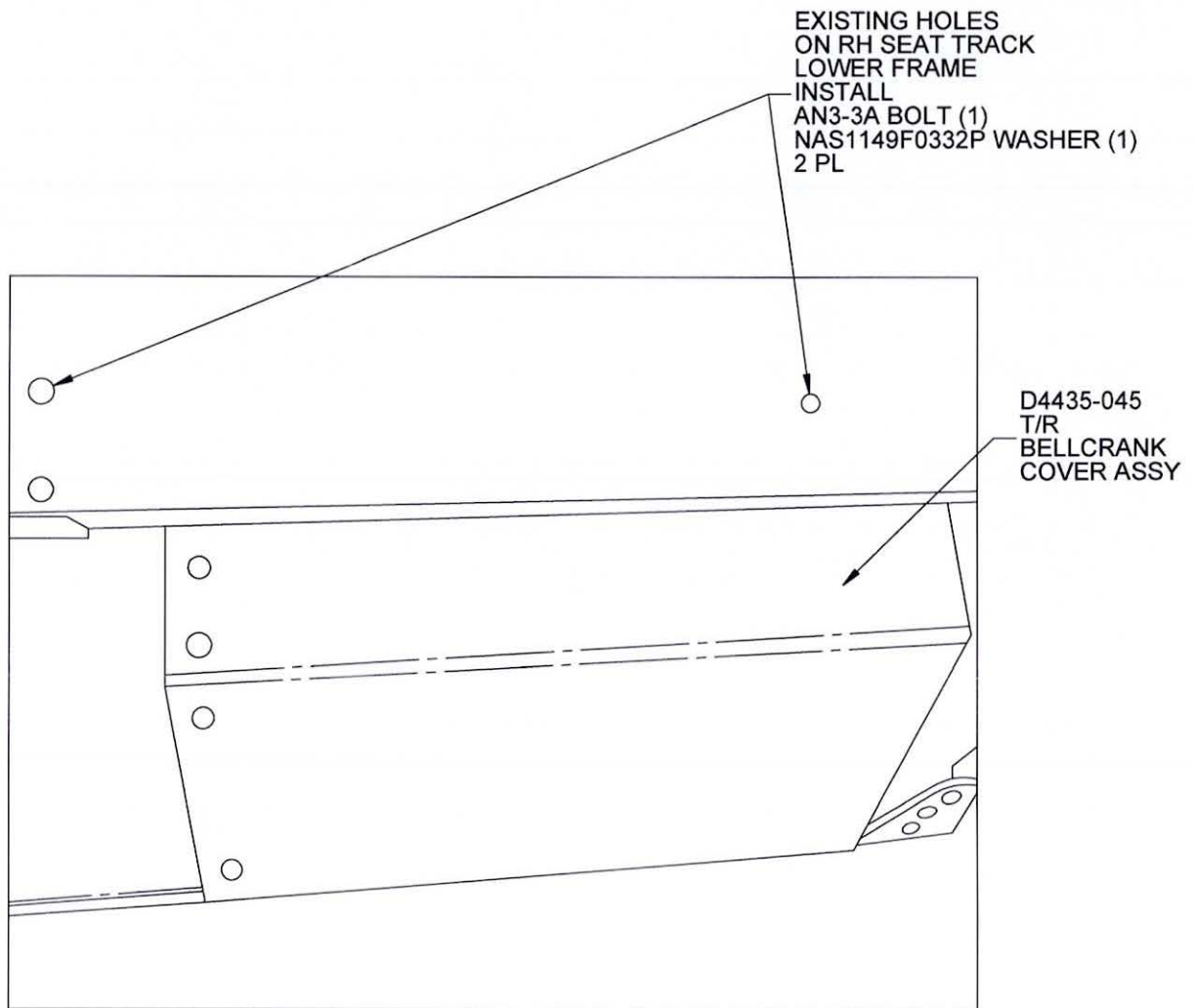


Figure 12a. D4435-045 T/R Bellcrank Cover Installation (-141)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SAD	DRAWING NO.	REV. J
MFG. APPR.	N/A	DSI 9590	SHEET 15 OF 22
APPROVED	SAD	TITLE	SCALE
DE APPR.	DS	FLOOR WINDOW CLOSE-OUT KIT	NTS
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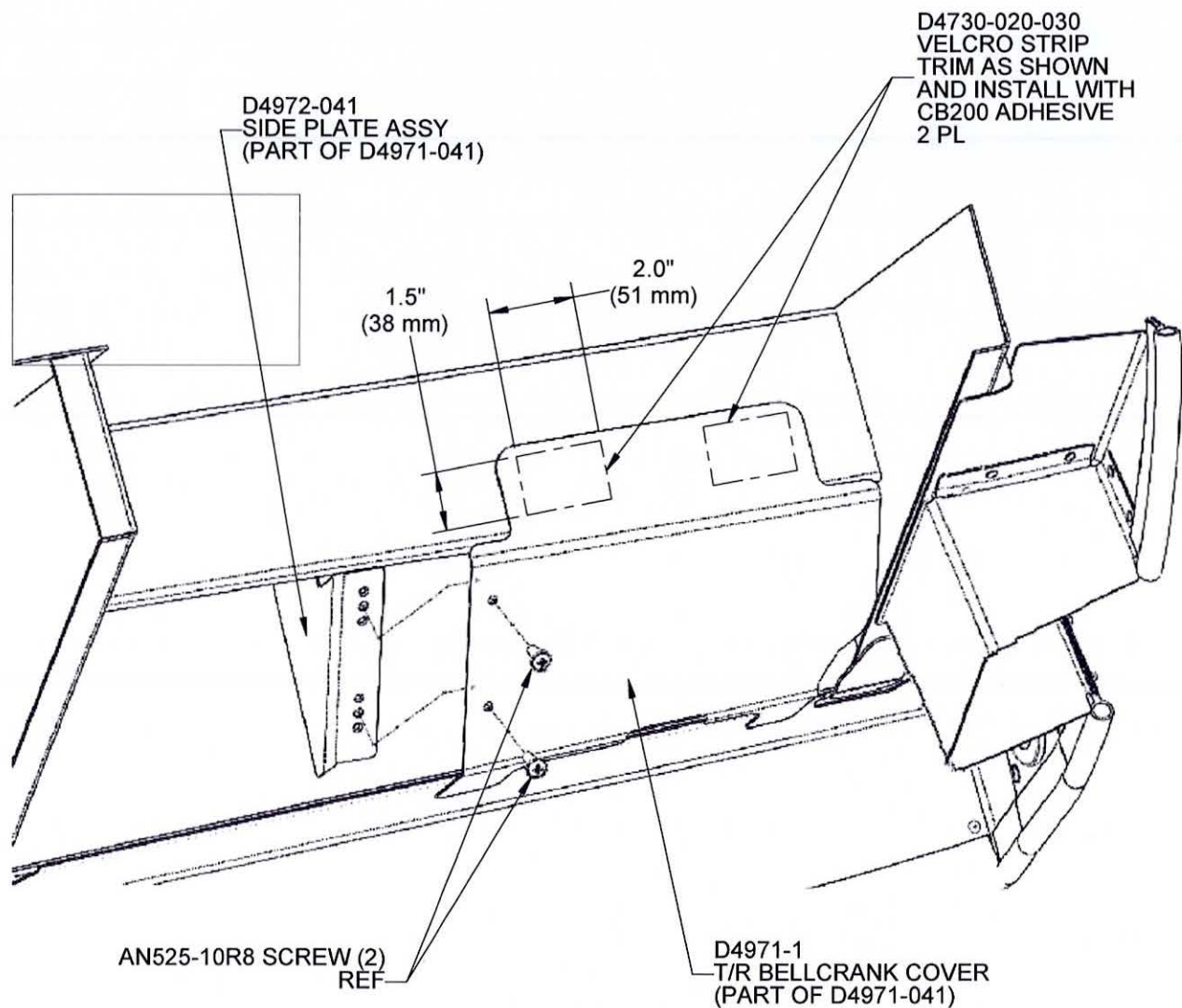


Figure 12b. D4971-041 T/R Bellcrank Cover Assy Installation (-143/-145/-147/-149)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SAD	DRAWING NO.	REV. J
MFG. APPR.	N/A	DSI 9590	SHEET 16 OF 22
APPROVED	SAD	TITLE	SCALE
DE APPR.	DS	FLOOR WINDOW CLOSE-OUT KIT	NTS
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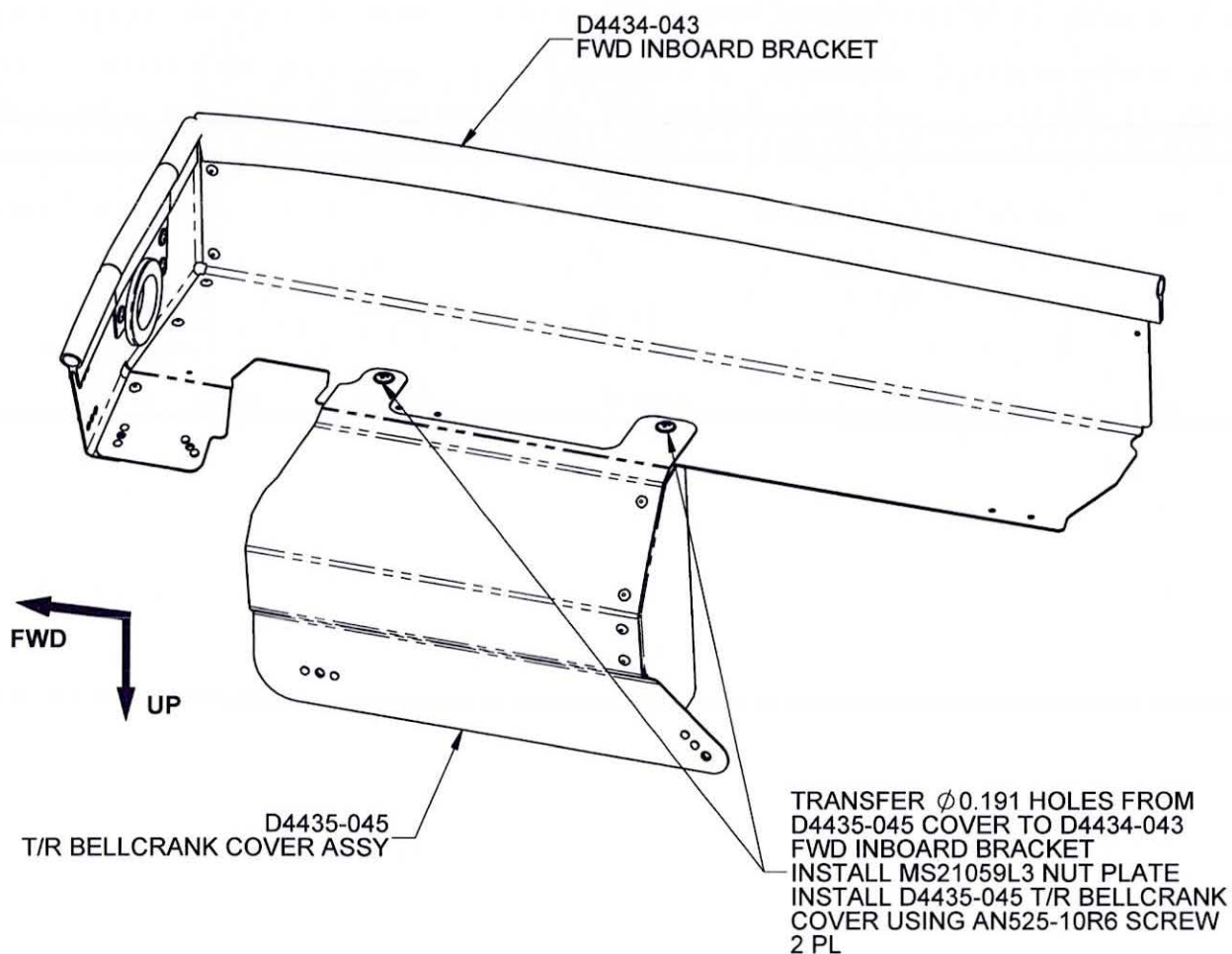


Figure 13a. D4435-045 Cover Installation (-141 ONLY)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SAD	DRAWING NO.	REV. J
MFG. APPR.	N/A	DSI 9590	SHEET 17 OF 22
APPROVED	SAD	TITLE	SCALE
DE APPR.	DS	FLOOR WINDOW CLOSE-OUT KIT	NTS
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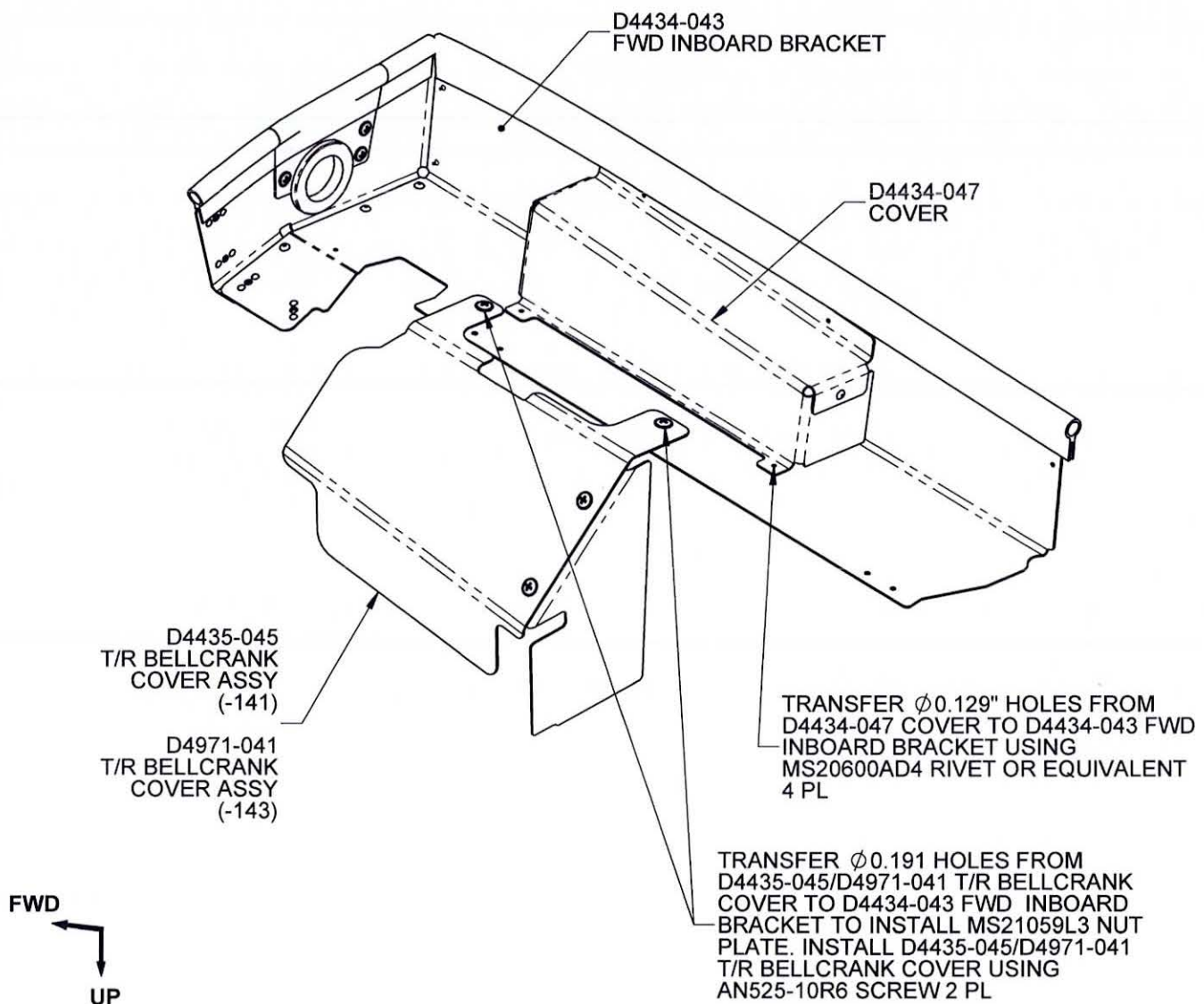


Figure 13b. D4971-041/D4435-045 & D4434-047 Cover Installation
(D4434-047 is Optional on -141)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SAD	DRAWING NO.	REV. J
MFG. APPR.	N/A	DSI 9590	SHEET 18 OF 22
APPROVED	SAD	TITLE	SCALE
DE APPR.	DS	FLOOR WINDOW CLOSE-OUT KIT	NTS
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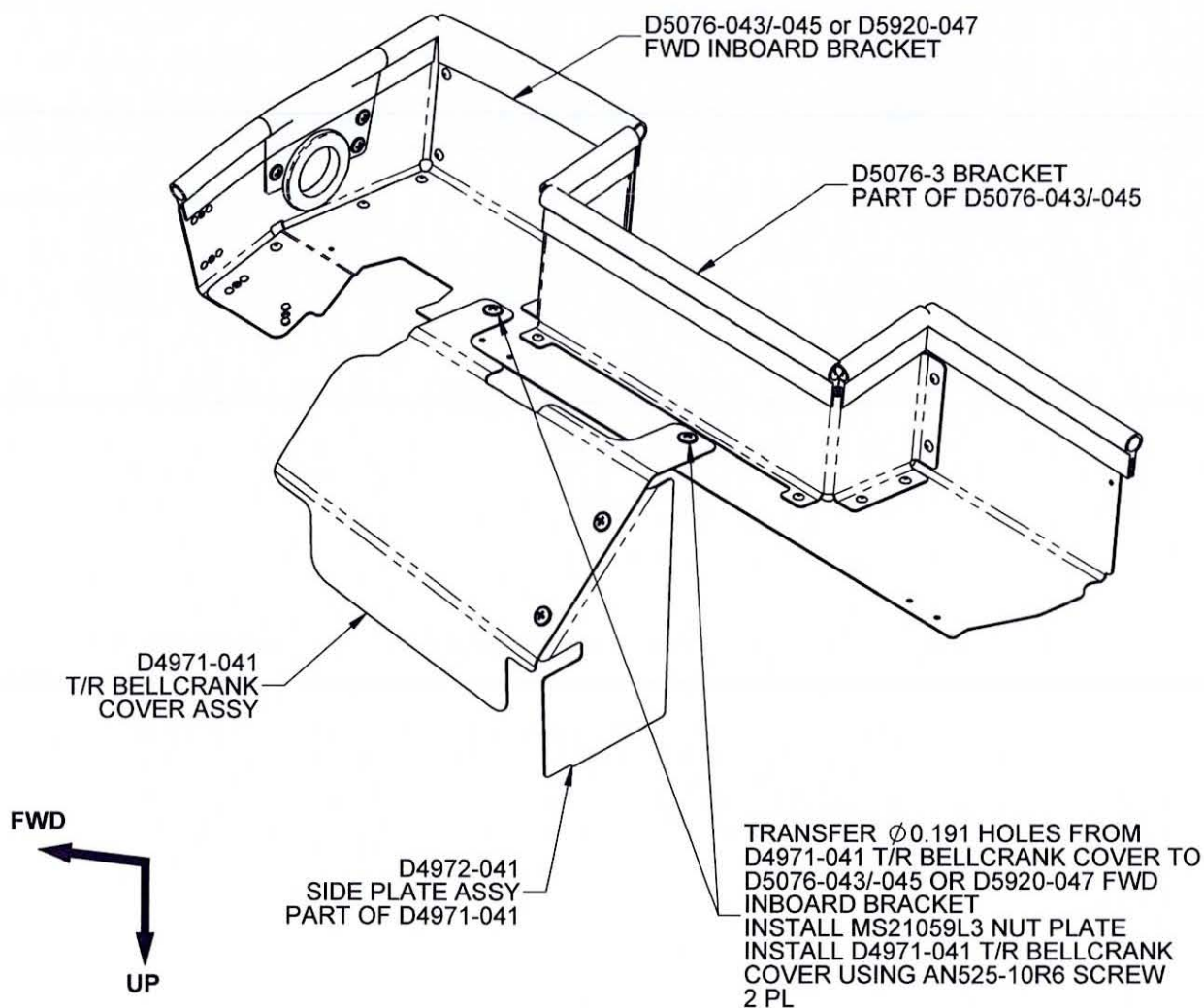


Figure 13c. D4971-041 INSTALLATION INTO D5076-043/-045 (-145/-147) OR D5920-047 (-149)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SAD	DRAWING NO.	REV. J
MFG. APPR.	N/A	DSI 9590	SHEET 19 OF 22
APPROVED	SAD	TITLE	SCALE
DE APPR.	DS	FLOOR WINDOW CLOSE-OUT KIT	NTS
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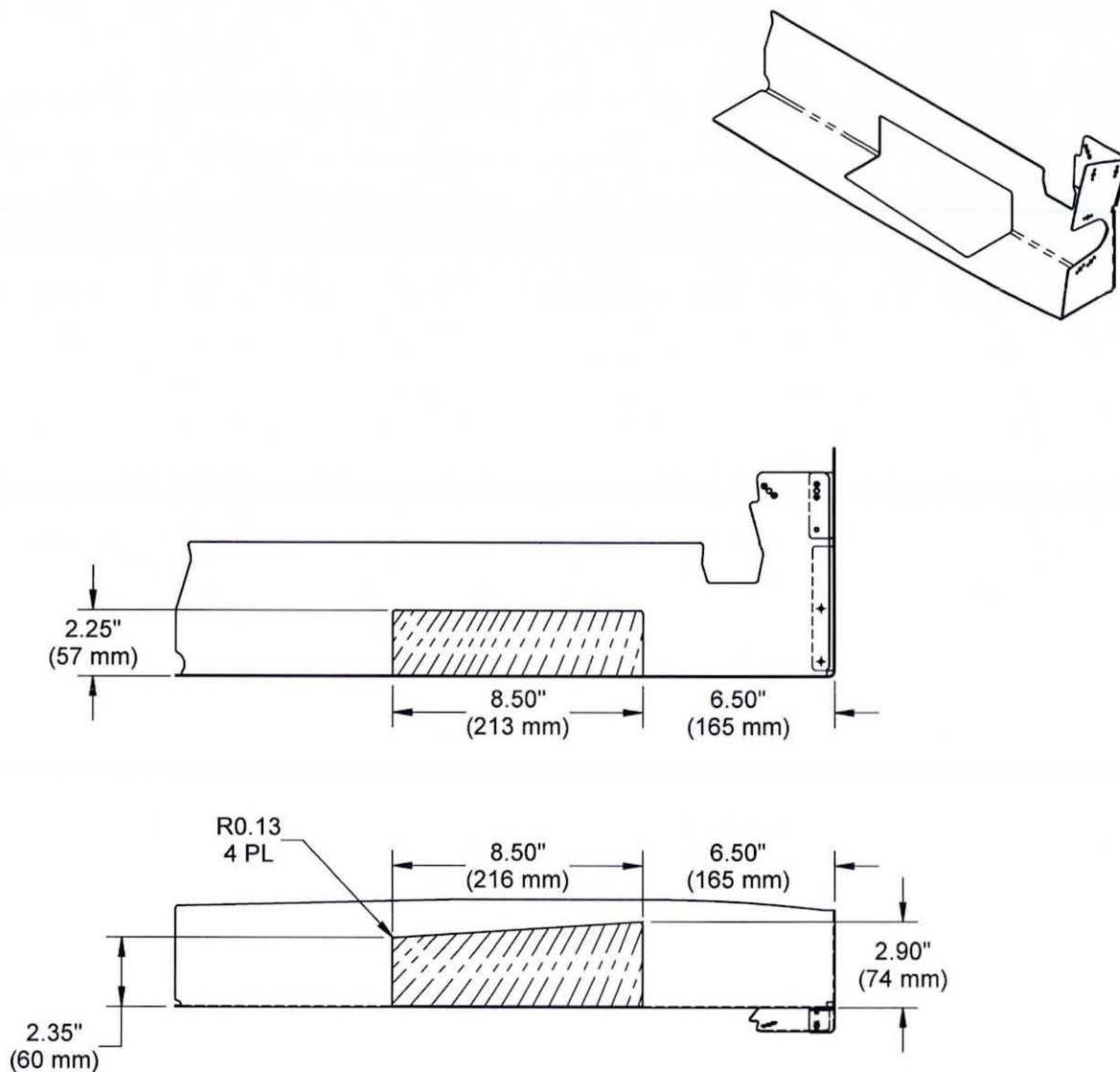


Figure 14. D4434-043/-049 Fwd Inboard Bracket Cutout

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SAD	DRAWING NO.	REV. J
MFG. APPR.	N/A	DSI 9590	SHEET 20 OF 22
APPROVED	SAD	TITLE	SCALE
DE APPR.	DS	FLOOR WINDOW CLOSE-OUT KIT	NTS
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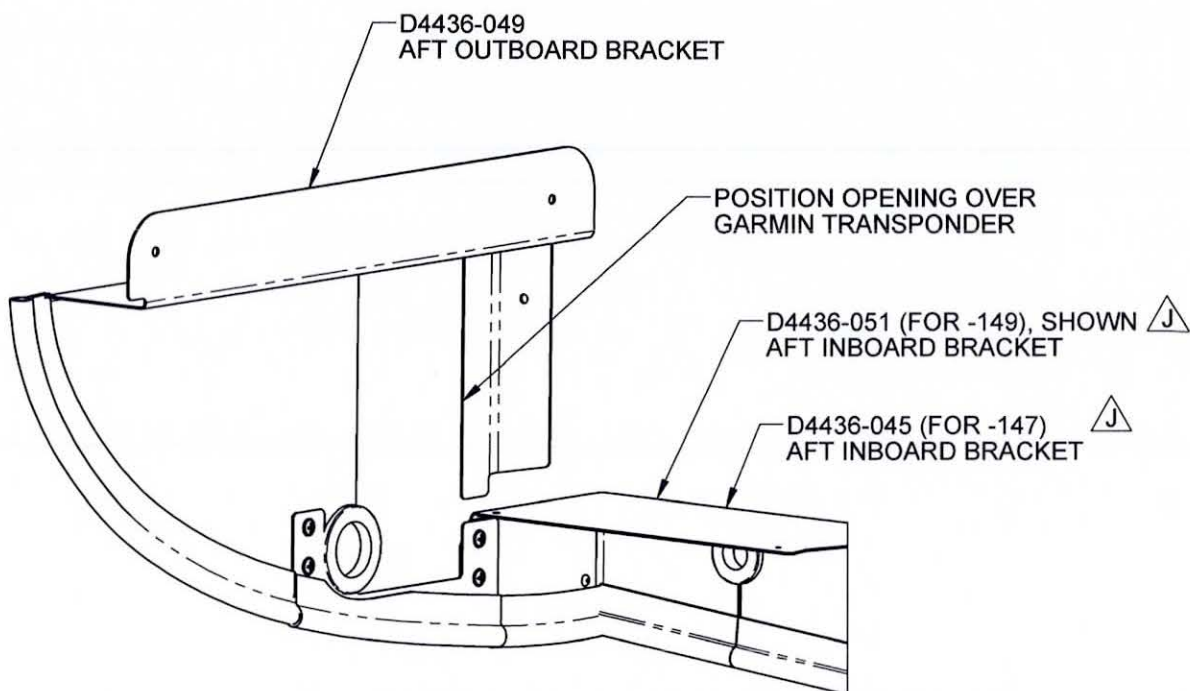
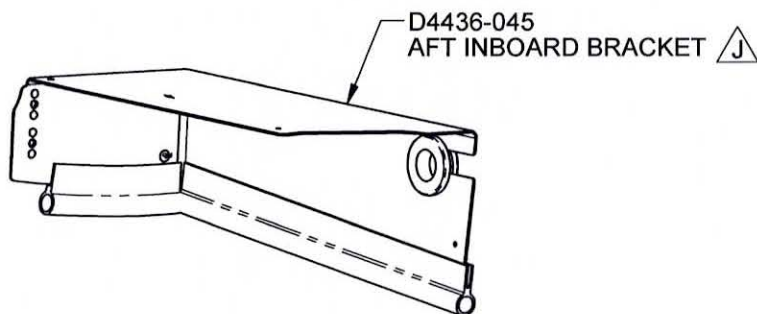


Figure 15. D4436-049 Aft Outboard Bracket Installation (-147/149 ONLY) △ J



APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SAD	DRAWING NO.	REV. J
MFG. APPR.	N/A	DSI 9590	SHEET 21 OF 22
APPROVED	SAD	TITLE	SCALE
DE APPR.	DS	FLOOR WINDOW CLOSE-OUT KIT	NTS
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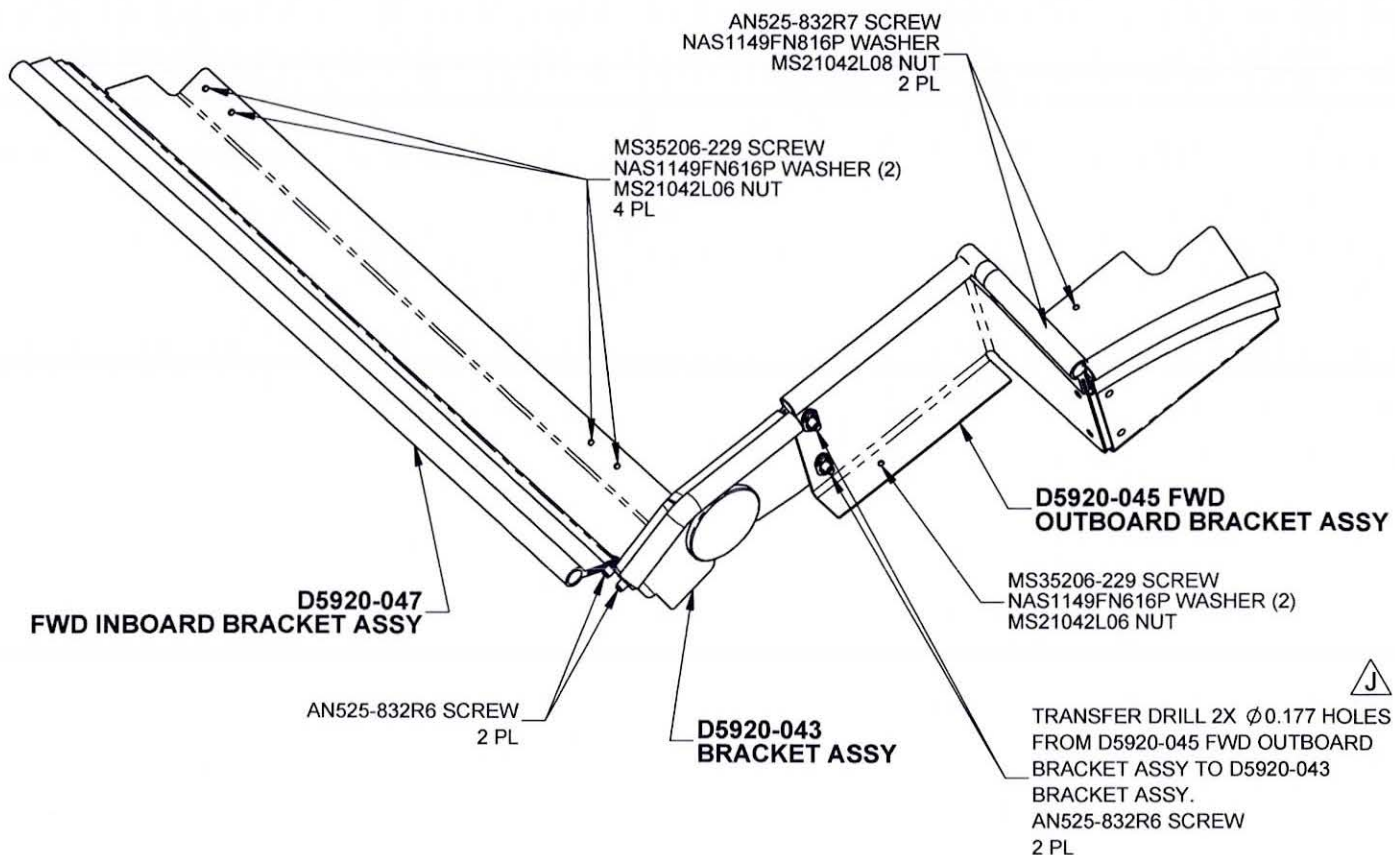


Figure 16. D5920-041 Fwd Bracket Assembly J
(USED ON D350-567-149)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SAD	DRAWING NO.	REV. J
MFG. APPR.	N/A	DSI 9590	SHEET 22 OF 22
APPROVED	SAD	TITLE	SCALE
DE APPR.	DS	FLOOR WINDOW CLOSE-OUT KIT	NTS
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